

Work Order ID 74217

Tuesday, September 27, 2011 11:19:39 AM

Page 1

Item ID: D139-799-015

Accept

Setup Start

Revision ID:

Stop

Item Name: Engine Wash

Start Date: 9/27/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 4.00

Customer:

Reference: ecn 11-639 - Rework

Approvals: Process Plan: *U*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D139-799

D

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-015
CHG003

DOU Ecn 11-639

8/11/12

105

0.00



Small Fab

Small Fab

Memo

PULL FROM STOCK:
1 X D139-799-015 B71514
3 X D139-799-015 B72351

SA 11/10/13

REWORK D4131-041 PER ECN11-639
ADD D4131-9 TO PART

*replace hoses (D4121-1's are OK)
D4121-3 (leech)
D4121-5C*

B 76372 Y.P

REV. ID

11/11/12

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Page 2

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Revision ID:

Stop



Item Name: Engine Wash

Start Date: 9/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 4.00



Customer:

Reference: ecn 11-639

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5 u/14/22		(70)			
110 Packaging Packaging	Pick Kit Memo	0.00 0.00							(4)
120 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		5 u/14/22		(70)			

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Tuesday, September 27, 2011 11:19:39 AM

Page 3

Item ID: D139-799-015

Accept

Setup Start

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Item Name: Engine Wash

Stop

Start Date: 9/27/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 4.00

Customer:

Reference: ecn 11-639

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP USING NEW B/N
NEW LABELS REQ'D
Identify and pack for shipping as per PPP D139-799-015
Location: _____
PPP rev: _____

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

DART
Dart Aerospace Ltd.
1270 ABERDEEN ST.
HAWKESBURY ONT CANADA K6A 1K7

TC APPROVAL #09-89
TEL: 1-613-632-5200

PN	D139-799-015	CHG	CHG002
DESC	Engine Wash	STC	SR02138SE
LOT	B72351	STC	
MODEL	Agusta AB/AW139	STC	

MADE IN CANADA

DART
Dart Aerospace Ltd.
1270 ABERDEEN ST.
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PN	D139-799-015	CHG	CHG002
DESC	Engine Wash	STC	SR02138SE
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MADE IN CANADA

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TC APPROVAL #09-89
TEL: 1-613-632-5200

PN	D139-799-015	CHG	CHG002
DESC	Engine Wash	STC	SR02138SE
LOT	B71514	STC	
MODEL	Agusta AB/AW139	STC	

MADE IN CANADA

CHG004
11-11-23
MF
11-11-23
11-11-21
(4)
11/11/23

Picklist Print

Page 1

Tuesday, September 27, 2011 11:19:36 AM

Work Order ID: 74217

Parent Item: D139-799-015

Parent Item Name: Engine Wash



Start Date: 9/27/2011

Required Date: 9/30/2011

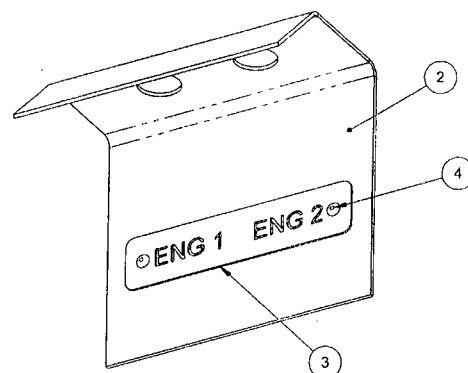
Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B 11.07.04 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERF BY:DD IPP Rev:C 11.09.27
PER CHG003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4131-9 		Manufactured	No				Each	0.0000		4			
Label Plate						B 74258				8		11/01/17	
* MS20615-3M3 		Purchased	No				Each	0.0000		8			
RIVET						M 111650				8		11/01/13	

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4131-045	BASE ASSEMBLY
2	1	D4131-3	BASE
3	1	D4131-9	LABEL PLATE
4	2	MS20615-3M3	RIVET



D4131-045 BASE ASSEMBLY



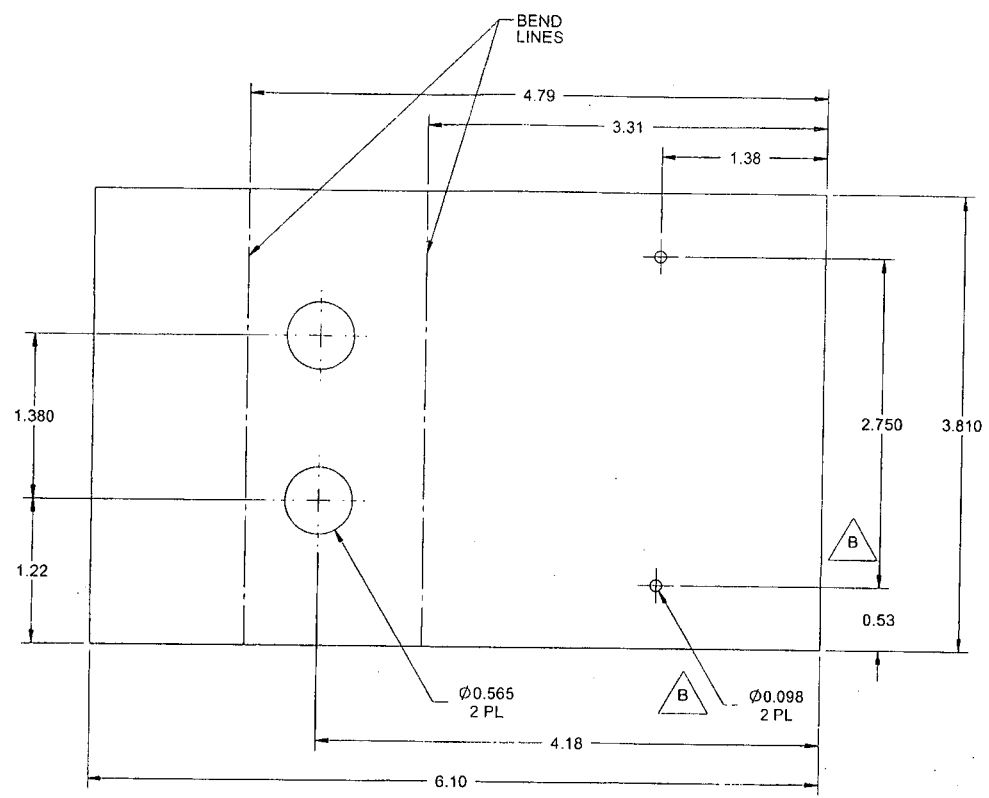
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 3 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MANIFOLD ASSEMBLY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
2011-09-21

1.38
- 1.350
1.030



D4131-3F FLAT PATTERN

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

RELEASED
2011-09-21

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4131	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 10	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MANIFOLD ASSEMBLY	
DATE	11.07.27	NTS	

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